

Work Order ID 57533

April 8, 2010 8:43:45 AM



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Item ID:	K10003	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, D205-634-011					
Start Date:	4/08/10	Start Qty: 4.00		Cust Item ID:		
Required Date:	4/15/10	Req'd Qty: 4.00		Customer:		
Reference:						
Approvals:	Process Plan:	Date: _____	Tooling: _____	Date: _____	Run	Start
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
IIN634,635	Rev F								

100		0.00							
	DOCUMENT CONTROL								
DC									
Document Control	Memo	0.00							
	Create White labels only per PPP K10003	CHG 007							

8/10/13

110	Pick Kit	0.00							
Packaging									
Packaging	Memo	0.00							

10-5-6

120	QC4- 100% Inspect kits for completeness	0.00							
QC									
Quality Control	Memo	0.00							

8/10/13



Work Order ID 57533




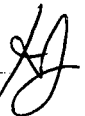

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Item ID: K10003 Accept  Setup Start 
Revision ID: Stop 
Item Name: Saddle, D205-634-011
Start Date: 4/08/10 Start Qty: 4.00  Cust Item ID:
Required Date: 4/15/10 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location <i>PK</i> Memo <i>Neer</i>	0.00 0.00							<i>4/10/10</i> 
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/05/17</i>  <i>BS 10-5-13</i> 

W 1005.74

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Work Order ID: 57533

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Comments: IPP : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP : J 06-07-25 As per DSI 9344 JLM
 IPP : K 06.11.17 Per K10003 Rev C KJ
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 4/08/10

Required Date: 4/15/10

Start Qty: 4.00

Required Qty: 4.00

AN4-51A
 Bolt

Purchased No

110 Each

186.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST361

186

112720

50

113121

100

113226

36

AN4-6A
 Bolt

Purchased No

110 Each

1,223.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST356

1223

112720

35

112829

288

112933

300

113149

600

AN4C47A
 Bolt

Purchased No

110 Each

65.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST361

65

113302

65

40
 22-0000
 8

10-5-7S

16x
 64-0000
 80

36
 M114523 10-5-7S

20
 16-0000
 14

16-5-7S
 M114653
 15X SP
 36
 5

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57533

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 IPP : J 06-07-25 As per DSI 9344 JLM
 IPP : K 06.11.17 Per K10003 Rev C KJ
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 4/08/10

Required Date: 4/15/10

Start Qty: 4.00

Required Qty: 4.00

AN6-12A ^{8x} Purchased No 110 Each 194.0000 ^{8x} 32.0000



Bolt

10-5-7 *[Signature]*

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST342 194

112314 194

AN960JD416 ^{8x2} Purchased No 110 Each 0.0000 128.0000



Washer

1114576 10-5-7 *[Signature]*

AN960JD616 ^{8x} Purchased No 110 Each 157.0000 32.0000



Washer

1113524 10-5-7 *[Signature]*
 (52)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST347 157

113149 157

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP : J 06-07-25 As per DSI 9344 JLM
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Start Date: 4/08/10

Required Date: 4/15/10

Start Qty: 4.00

Required Qty: 4.00

D2570 Manufactured No 110 Each 233.0000 96.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST018

233

53778

14

55003

219

D2571 Manufactured No 110 Each 17.0000 4.0000



Saddle, Fwd Out 205

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST425

9

43564

4

47564

4

54929

1

Main Warehouse

ST433

8

56747

8

120



24x

10-5-75
B57507

57616 10-5-65
B58250 3x
10-5-125

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57533

Parent Item: K10003

Parent Item Name: Saddle, D205-634-011


Comments: IPP : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP : J 06-07-25 As per DSI 9344 JLM
 IPP : K 06.11.17 Per K10003 Rev C KJ
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 4/08/10

Required Date: 4/15/10

Start Qty: 4.00

Required Qty: 4.00

D2572

 Saddle, Fwd In 205

Manufactured No 110 Each 11.0000 4.0000



B-58100 10-5-125

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST425

4

43565

4


Main Warehouse

ST433

7

56748

7

D2573

 Saddle, Aft Out 205

Manufactured No 110 Each 19.0000 4.0000



B57630 10-5-4
 (57)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST425

12

43566

4

47566

4

52911

4

Main Warehouse

ST434

7

56749

7

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Start Date: 4/08/10

Required Date: 4/15/10

Start Qty: 4.00

Required Qty: 4.00

D2574

Manufactured No

110

Each

16.0000

4.0000



Saddle, Aft In 205

4x

1357631 10-5-68
 (5x)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST425

8

43567

4

56398

4

Main Warehouse

ST434

8

56750

8

D2747

Manufactured No

110

Each

193.0000

16.0000



Set Screw

20



5x

10-5-7

(5x)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST023

193

39224

4

51921

189

20

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 IPP : J 06-07-25 As per DSI 9344 JLM
 IPP : K 06.11.17 Per K10003 Rev C KJ
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 4/08/10

Required Date: 4/15/10

Start Qty: 4.00

Required Qty: 4.00

D2876

 Saddle Spacer

Manufactured No 110 Each 133.0000 8.0000

10-5-75

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST028	133	
	42364	86	
	51540	47	

10

D2877


 Saddle Spacer

Manufactured No 110 Each 65.0000 8.0000

10-5-7 5

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST028	65	
	47292	28	
	51541	37	

10

D3405-041

 Lug Assembly

Manufactured No 110 Each 11.0000 4.0000

BS6835 10-5-65

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST474	11	
	53887	11	

1

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Start Date: 4/08/10

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 IPP : J 06-07-25 As per DSI 9344 JLM
 IPP : K 06.11.17 Per K10003 Rev C KJ
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ

Start Qty: 4.00

Required Qty: 4.00



D3533-1

Manufactured No

110

Each

163.0000 8.0000

Set Screw

10-5-17 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST069

163

51602

163

110

Each

1,566.000 96.0000

MS21042L4



Nut

Purchased

No

120

10



24X

M114416 SP 10-5-17 SX

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST139

2

111827

2

Main Warehouse

ST300

1564

113422

556

114108

1000

9063

8

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Work Order ID: 57533



Parent Item: K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 4/08/10

Required Date: 4/15/10

Comments: IPP: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP: J 06-07-25 As per DSI 9344 JLM
 IPP: K 06.11.17 Per K10003 Rev C KJ
 IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

X5

Purchased

No

110

Each

610.0000 20.0000



Nut

Sx

16

M112492

10-S-75

Sx

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

40

104603

40

Main Warehouse

ST301

570

113064

170

114181

400

9

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5.0 PARTS LIST

Item	634 011	634 015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21		1				D2572	SADDLE, FWD INSIDE
22		1				D2573	SADDLE, AFT OUTSIDE
23		1				D2574	SADDLE, AFT INSIDE
24		8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN5-12A	BOLT
28	8	8				AN930JD616	WASHER
29	16	16				AN4-6A	BOLT
30	2	2				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	2	2				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
41		4				D3407-041	TOW RING (REPLACES D2968-041)
42		4				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C47A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2977	SADDLE SPACER

* DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F

Date: 08.10.07

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries